



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3914-041
Job Sheet 169506



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 1/19/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV:C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/18/18	1/18/18	0.00	0.00	Start Up Large Fab-5		D.M.L 18-2-3
100	Large Fab	1 pcs	1/18/18	1/18/18	0.00	6.67	Large Fab 1		18-2-5
110	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC9		PD 18-02-06
120	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		PD 18-02-06
130	Powdercoat	1 pcs	1/18/18	1/18/18	0.00	0.40	Powdercoat4		BR 18-02-07
135	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC3		BEB 18-02-08
140	HandFinish	1 pcs	1/19/18	1/19/18	0.00	0.80	HandFinish3		BEB 18-02-08
150	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC3		M 18-2-13
160	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-2		BEB 18-02-16
170	QC21-SA	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		21 FEB 16 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

M138700 START: 12:55 OUT: 320° FINISH: 1:25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 5033599	2	51	0	0
	D3914-15034699	2	16	0	0
	D3914-75032228	2	16	0	0
	D4016-35010799	3	49	0	0
	D4018-55035012	9	27	0	0
	5029997 -D4020-55032138	1	6	0	0
	D4021-35032438	1	11	0	0
	..D4035-0435032415	2	18	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

wing walk M138711

DART
AEROSPACE
S038633

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Long Basket Lid Assembly (350)

PART NO: D3914-041

Original Serial #: S038633

Revision:

Operation: Start up Operation 02/03/18

Change No:

Job No: 169506

Master Unit 000338



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